

Work Order ID 83995

May-01-12 10:35:48 AM

83995

Page 1

Item ID: D2022-101

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spacer

Start Date: 01/05/2012 Start Qty: 100.00

100

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/01 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2022	rev 97.01.14								

100

0.00

100

Hardinge

Hardinge CNC Lathe Small

Memo

Note: 257" dia drill
1-Turn as per folio FA206 & dwg
FOLIO REV: AA
DWG REV: N/A

2-Deburr as required

0.00

12/02/04 JF/ox

100

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

12/02/04 JF/ox

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 01/05/2012 Start Qty: 100.00

100

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

B.A 12/07/05

100 ✓

Quality Control

130

Identify as per dwg & Stock Location: SSA 0.00***130***

Packaging

Memo

0.00

100x SD
12-7-5

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

✓ 12/7/6
ME
12-07-05

Quality Control

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Picklist Print

May-01-12 10:35:51 AM

Page 1

Work Order ID: 83995

83995

Parent Item: D2022-101

D2022-101

Parent Item Name: Spacer

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP D02.03.07 Now made in house NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	25.6000	0.03	3			

M6061T6R0 750

**

6061-T6 Round Bar .750"

Location	Loc Qty	Loc Code
MAT012	11.6	
120734	11.6	
MAT013	14	
→ 121282	14	

3

OK 12/07/05

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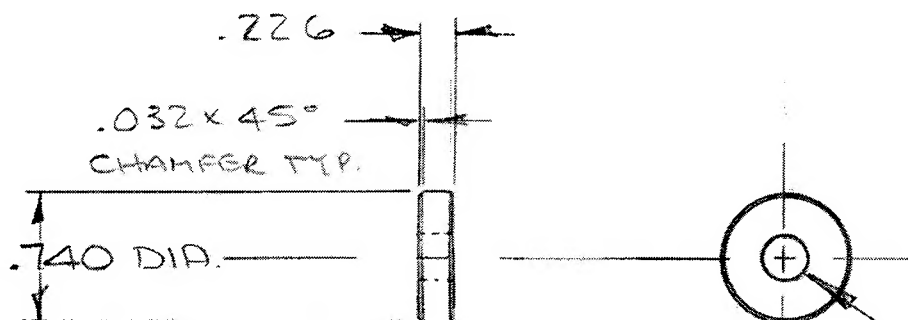
NOTE: Date & initial all entries

RELEASED
970119 BW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 83995 MCL

12/05/01



DRILL 'F' (.257) DIA. IN -101
DRILL P (.323) DIA IN -103

D2022-101
D2022-103

MAT'L: ALUMINUM 6061-T6 (QQ-A-225/8)



D2022

D2022-103	SPACER 5/16	ALUM 6061-T6	QQ-A-250/8
D2022-101	SPACER 1/4	ALUM 6061-T6	QQ-A-250/8

REVISION DRAWN APPROVED		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523 BASIC CODE DIA. DASH NO. IN-HEAD NEAR SIDE IN-HEAD FAR SIDE D-DIMPLE DASH NO. OF SHEETS C-COUNTERSINK LENGTH DASH NO. IN-SPOTWELD BASIC CODES BA-MS20470AD BB-MS20476AD		QTY. REQUIRED APPROVAL		PART NO. ITEM DESCRIPTION MATERIAL SPEC./VENDOR			
DESCRIPTION OF CHANGE		REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE FINISHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER SAE - S - 7742 5. HOLES PER AND 12367 LIMITS 1. TOLERANCES — .001 & .030 .001 & .010 2. ANGLES 1 1/2° 3. PARALLELISM 1 .0025 4. ECCENTRICITY .008 MAX 5. SYMMETRY ABOUT ALL MAT. CENTRE LINES .005		REPORT ALL DISCREPANCIES — DO NOT SCALE		CONTRACT NO. DRAWN BRADLEY DATE 4/20/01 DESIGN BRADLEY STRESS CHECKED CLIENT		DART AERO ACCESSORIES INC CLIENT TITLE SPACERS CODE D2022 SCALE 1:1 SHT 1 OF 1			

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